

ASAP PLS. Dart Aerospace Ltd.

Date: Tuesday, 11/21/2006 10:52:42 AM
User: Chantal Lavoie











Process Sheet

| | | | |
|----------------------------------|---------------------------------------|-------------------------|--------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FITTING |
| Job Number | : 29560 | | |
| Estimate Number | : 11396 | | |
| P.O. Number | : <u>N/A</u> | Part Number | : D32993 |
| This Issue | : 11/21/2006 | Drawing Number | : D3299 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <u>N/A</u> | Drawing Revision | : B |
| Previous Run | : <u>N/A</u> | Material | : <u>N/A</u> |
| Written By | : <u>[Signature]</u> | Due Date | : 11/28/2006 |
| Checked & Approved By | : <u>[Signature]</u> | Qty: | <u>21</u> Um: Each |
| Comment | : Est: A 04.10.04 New issue KJ/JLM | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|----------------------------------------------|
| 1.0 | M6061T6H1000 | 6061-T6 1" HexBar |
|   | | |
| Comment: Qty.: 0.1925 f(s)/Unit Total : 1.5397 f(s) 6061-T6 1" HexBar Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex (M6061T6H1.000) Identify as D3299-3 Batch: <u>1102605</u> | | |
| 2.0 | HAAS1 | COBAA lathe (HAAS CNC VERTICAL MACHINING #1) |
|   | | |
| Comment: Machine as per Folio FA452 and Dwg D3299 Deburr | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|   | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 4.0 | QC8 | SECOND CHECK |
|   | | |
| Comment: SECOND CHECK | | |
| 5.0 | OUTSIDE SERVICE | OUTSIDE SERVICES |
|   | | |
| Comment: Sub-Contracting OUTSIDE SERVICES Issue P/O: <u>2544</u> Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/12

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 10:52:42 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 29560

Part Number: D32993

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

B 06/12/08 (21)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.12.11 (21)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *S421*

10 4/12/12 (21)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/12 (21)

Job Completion



U 06/12/12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

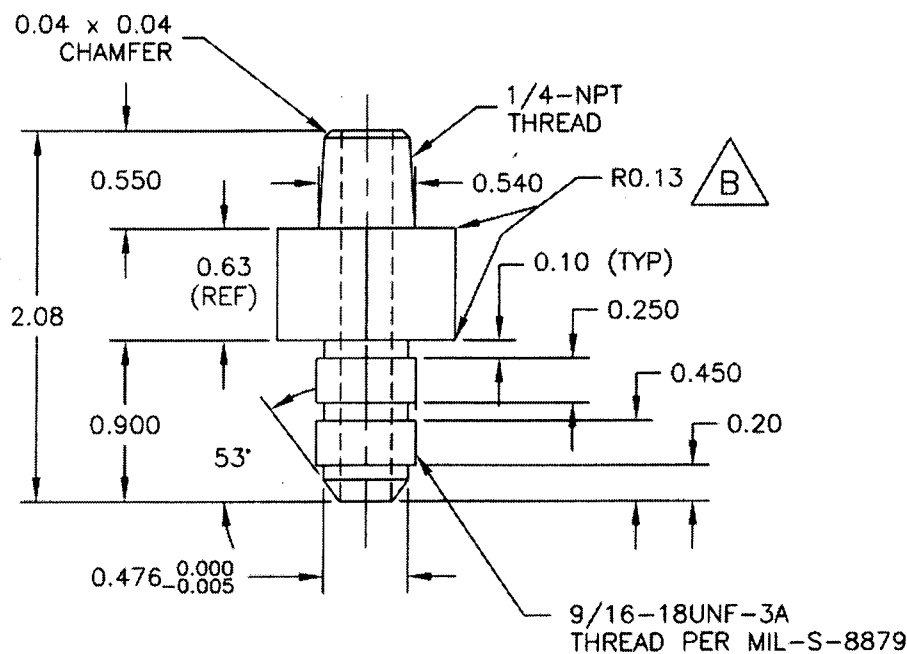
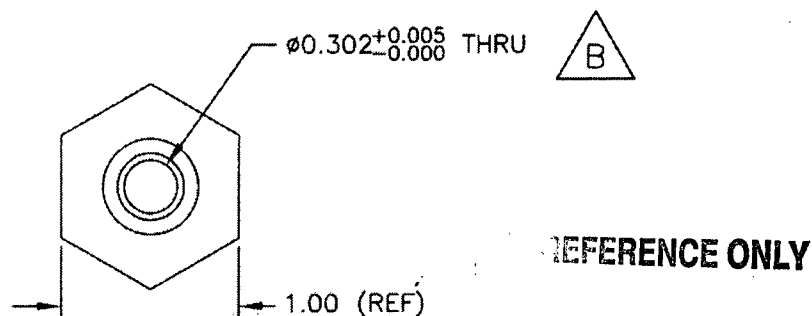
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|------------------------|-------------------------|---------------------------------------------------|------------------------|
| DESIGN [Signature] | DRAWN BY [Signature] | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3299 | REV. B SHEET 2 OF 3 |
| DATE 05.04.28 | | TITLE FITTING | SCALE 1:1 |

RELEASED
05.04.28**D3299-3****D3299-3 NOTES:**

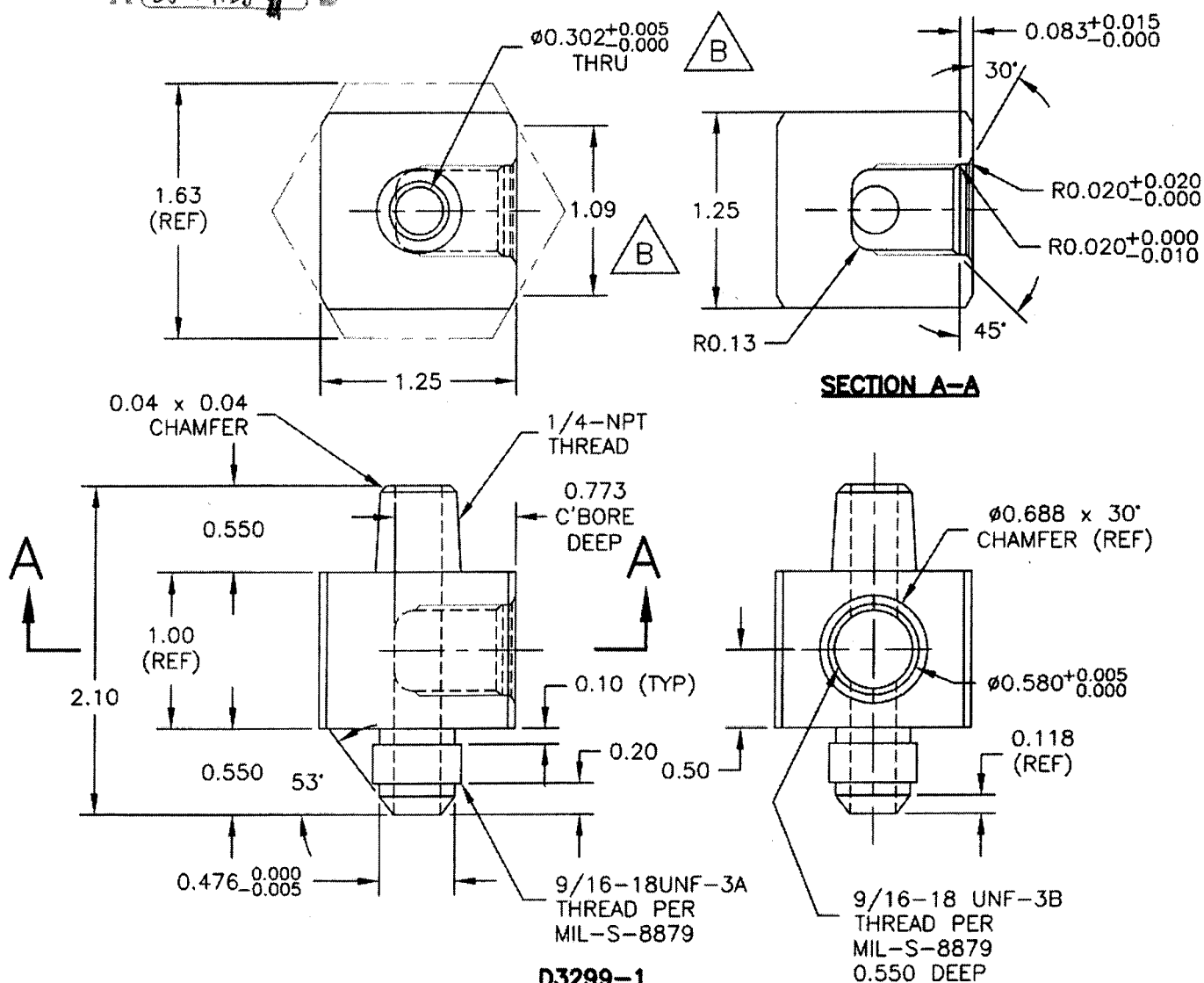
- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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DART

| | | | |
|------------------|---------------|----------------------------------------------------------|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3299 | REV. B SHEET 1 OF 3 |
| DATE 05.04.28 | | TITLE FITTING | SCALE 1:1 |
| A | 04.07.06 | NEW ISSUE | |
| B | 05.04.28 | 1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$ | |

RELEASED
05.04.28 #**D3299-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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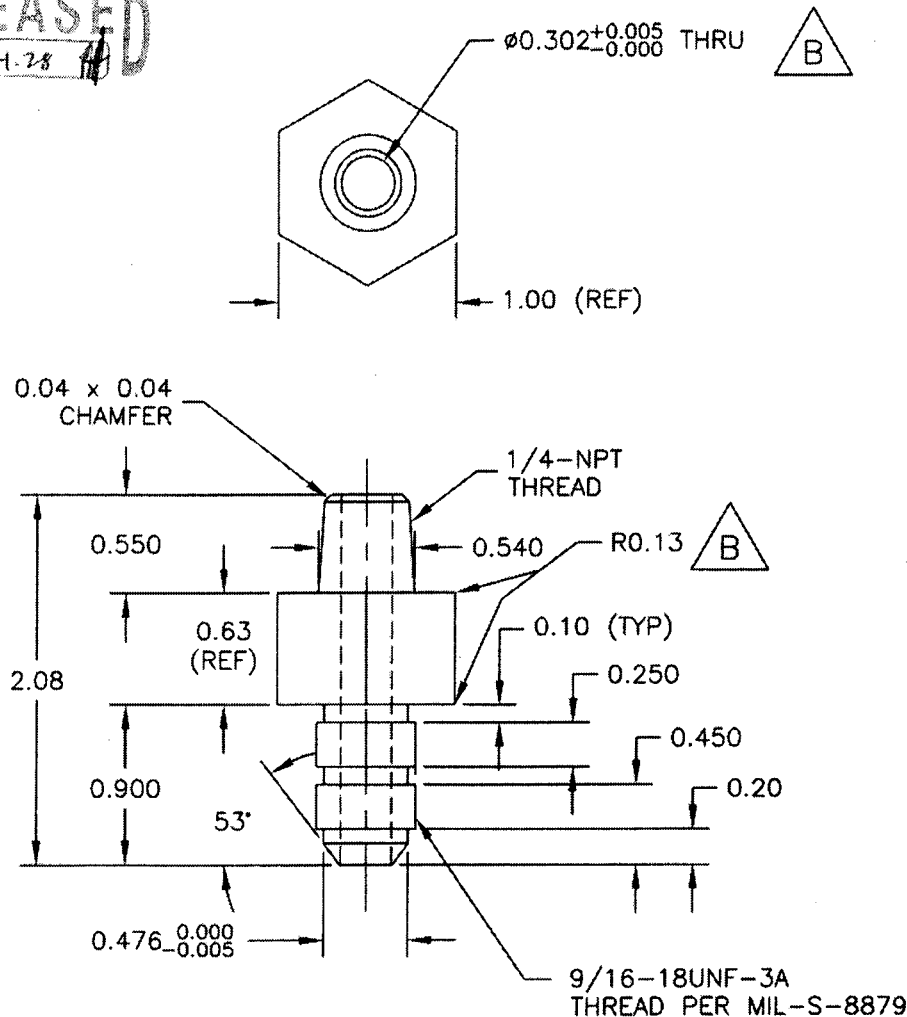
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.574 hours pge.



| | | | |
|------------------|---------------|---------------------------------------------------|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3299 | REV. B SHEET 2 OF 3 |
| DATE 05.04.28 | | TITLE FITTING | SCALE 1:1 |

RELEASED
05.04.28



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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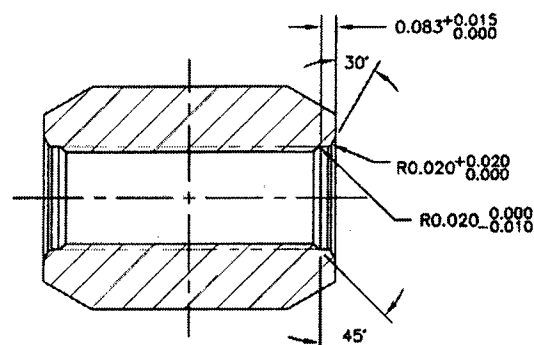
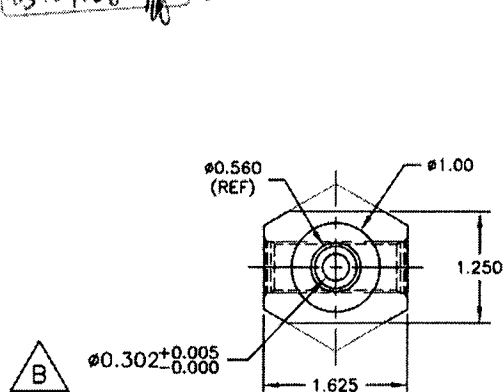
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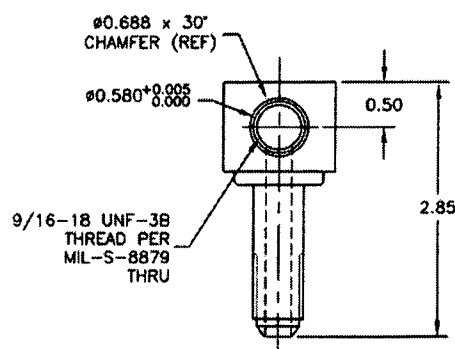
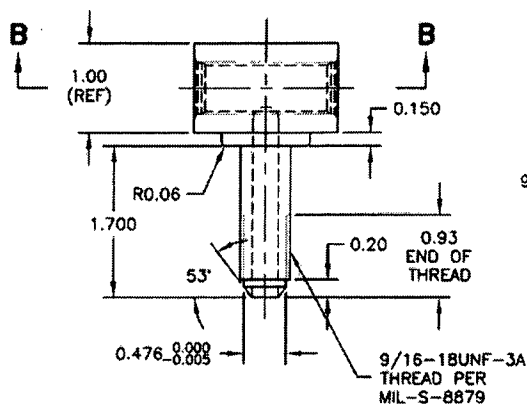


| | | | |
|------------------|---------------|---------------------------------------------------|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3299 | REV. B SHEET 3 OF 3 |
| DATE 05.04.28 | | TITLE FITTING | SCALE 1:2 |

RELEASED
05.04.28 #



SECTION B-B
SCALE 1:1



D3299-5

REFERENCE ONLY

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/B OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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| | | |
|------------------------------|----------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 29560 |
| Description: Fitting | | Part Number: D3299-3 |
| Inspection Dwg: D3299 | Rev: B1 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------------------------|-----------------------------|------------------|--------|--------|----------------------|----------|
| 1.00 | +/-0.030 | 1.005 | ✓ | | | |
| Ø0.302 | +0.005/-0.000 | .305 | ✓ | | | |
| 0.550 | +/-0.010 | .545 | ✓ | | | |
| 0.63 | +/-0.030 | .625 | ✓ | | | |
| 2.08 | +/-0.030 | 2.078 | ✓ | | | |
| 0.900 | | .906 | ✓ | | | |
| 53° | | 53° | ✓ | | | |
| 0.476 | -0.005/+0.000 | .474 | ✓ | | | |
| MOW for 9/16"-18 | Min = 0.5653 Max = 0.573 | .572 | ✓ | | | |
| 0.200 | +/-0.030 | .215 | ✓ | | | |
| 0.450 | +/-0.010 | .451 | ✓ | | | |
| 0.10 | +/-0.030 | .085 | ✓ | | | |
| Length of Engagement for 1/4 NPT 0.227 | +/-0.010 | .225 | ✓ | | | |
| | | | | | | |
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|--------------------------|-------------------------|----------------------------|-----|
| Measured by: J.F. | Audited by: S.L. | Prototype Approval: | N/A |
| Date: 06/11/21 | Date: 06/11/22 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 04.09.17 | New Issue | KJ/JLM | |
| B | 05.05.25 | -0.005/+0.000 added to 0.476 | KJ/JLM | |

REFERENCE ONLY

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

51578

30-Nov-2006

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE**CERTIFICAT DE CONFORMITE****PURCHASE ORDER/****NO. DE COMMANDE:**

00002544



| ITEM | COMMANDE ORDERED | QUANTITE SHIPPED | PART NUMBER & DESCRIPTION | PART PROCESS & TREATMENT |
|------|---------------------|---------------------|---------------------------|--------------------------------------------------------------------------------------|
| 1 | 21 ✓ | 21 | D3299-3 ✓ B29560 ✓ | AS PER DWG D3299 REV. B BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER |

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

□ Directeur de la Qualité / Q.A. Manager □ □ □

